

## SPLIT-2

Form in process

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33580

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5



2.05

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/20 (x6-012)

5.0

QC9



VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

N/A En 07/08/20

6.0

HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m

07.01.25

6

7.0

QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ph 07.10.01 (1)

8.0

D3560042



ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

ARM WELDMENT

334965

Ph

Ph 07.10.04 PTO

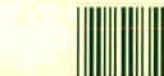
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9.0

D3560044



ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

ARM WELDMENT

Batch:

334967

Ph 07.10.04

5

10.0

MS20600AD4W5



Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 216.0000 Each(s)

Blind Rivet

batch:

1105125

(96) Ph 07.10.04 = (3)

11.0

SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

a.m 07.10.04 (2)

Drill Rivet holes as per dwg D3562. Touch up alodine.

Ph 07.10.04 = (3)

Rivet legs using Magnabond as per dwg D3562.

a.m 07.10.04 Ph 07.10.04 = (3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.07.17	1B.5	Qty (2) DZ808 SPACER B/N <u>B32752</u> PRESS FIT AFTER POWDER COAT. TEMPORARILY SECURE W MASKING TAPE UNTIL ASSEMBLY INTO D412-636-031-034 STEP. PERMANENT CHG PER DWG	mf	07-10- 17	1	07.07.17 P QSI 0472	07.10.18	
07/10/10	# 1B.6	ADD inspect acfs after installing DZ808	5	07/10/10		07.10.18	07/10/10	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/17	#	He counter sink was not done on the arms were only noticed at assembly. R.C. Humman error	QSI 0412	investigate why this happened	En 07/10/17	En 07/10/18	QSI 0412	En 07/10/17
				counter sink holes.	mf 07-10- 17			
				re align the asper	mf 07/10/17			
				AS2005	07/10/17			
			QSI 0412	touch up with white marker.	mf 07/10/17	En 07/10/18	QSI 0412	En 07/10/17

NOTE: Date &amp; initial all entries

Date: Tuesday, 7/17/2007 1:59:32 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33580

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description:

Ensure to wipe off any excess magnabond of the step

a.m 07-10-04 (2)

A/R

Magnabond 6398

Batch:

3104677

FL 07-10-04 (3)

12.0

QC5

INSPECT WORK TO CURRENT STEP



check in Helicopter



Comment: INSPECT WORK TO CURRENT STEP

FL 07-10-09 (x5-042)

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562 & QSI 004. Inspect for foreign objects as per QSI 024.

FL 07-10-09 5

A/R

Aluminum Rod

M103794

2-Grind end cap welds flush as per Dwg D3562

a.m

07-10-10

(5)

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

FL 07-10-10

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FL 07-10-10 (x5-042)

16.0

POWDER COATING

POWDER COATING



M105068



(6x) (x5-042) (PFD) →

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-FL 07/10/11

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M105694

FL 07/10/11 (5)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mpf 07-10-17 (5)

185 \* SEE W/D CHG

186

QC#5 inspect work to current step

FL 07/10/11 (5)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Hydro	#155	touch up welded ends with Alclad as per ASZ 005 4.1	MS	07-0-005	5		MS Hydro	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 1:59:32 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33580

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

PPP 33577

6/7/10/18(4)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

6/7/10/18(4)

Job Completion



6/7/10/18

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

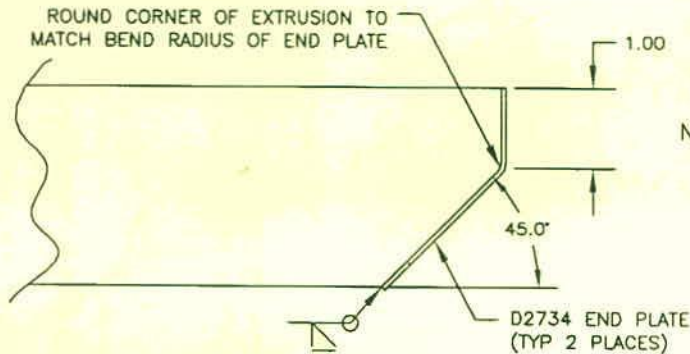
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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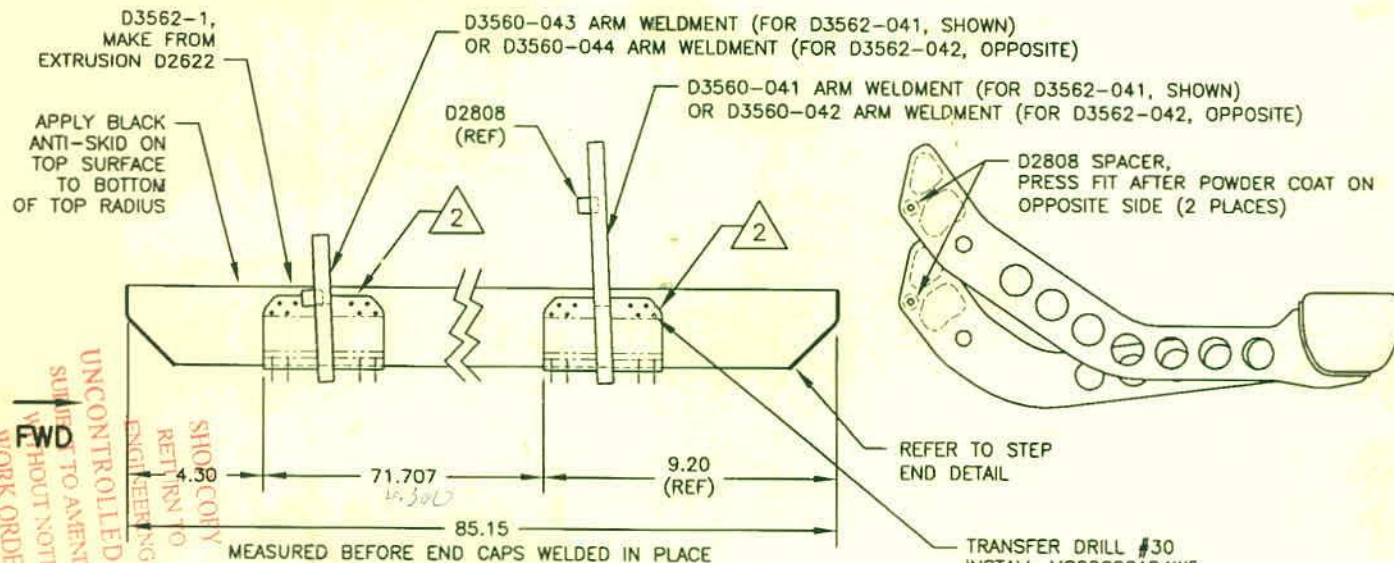
NOTE: Date & initial all entries

**DART****RELEASED**  
07.06.24

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



**TYPICAL STEP END DETAIL**  
NOT TO SCALE



**D3562-041 LH STEP ASSEMBLY (SHOWN)**  
**D3562-042 RH STEP ASSEMBLY (OPPOSITE)**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
  - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
  - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
  - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. C
CP	CP		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
CP	CP	D3562	
DATE	TITLE	SCALE	
07.06.19	STEP ASSEMBLY	NTS	
A	06.09.26	NEW ISSUE	
B	07.01.15	ARMS NOW RIVETED TO STEP	
C	07.06.19	NOW MAGBND, ADD D2808, RMV 4 RVTS	

